

Date: Monday, 5/14/2007 7:12:29 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32329
Estimate Number : 12865
P.O. Number : N/A
This Issue : 5/14/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run :
Written By :
Checked & Approved By :
Comment : est rev A 07.05.10 new issue EC

Drawing Name : DART 13-MAN 3-POINT SHOULDER HARNESS KIT
Part Number : D412702041B
Drawing Number : D412702041B
Project Number : N/A
Drawing Revision : D
Material : N/A
Due Date : 5/15/2007 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-702-041B CHG001

KJ 07.05.16

2.0 D412702059 GROMMET KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

GROMMET KIT

batch: B 32327 ✓

3.0 D412702101B HARNESS ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

HARNESS ASSEMBLY

batch: B 32332 ✓

4.0 D412702103B HARNESS ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

HARNESS ASSEMBLY

batch: B 32333 ✓

5.0 D412702105B HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

HARNESS ASSEMBLY

batch: B 32334 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32329

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D412702107B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

HARNESS ASSEMBLY

batch: B32335 ✓

7.0

D412702109B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

HARNESS ASSEMBLY

batch: B32336 ✓

8.0

D412702111B

HARNESS ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

HARNESS ASSEMBLY

batch: B32337 ✓

9.0

D412702113B

HARNESS ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

HARNESS ASSEMBLY

batch: B32338 ✓

10.0

D412702115B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

HARNESS ASSEMBLY

batch: B32339 ✓

11.0

D412702117B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

HARNESS ASSEMBLY

batch: B32340 ✓

12.0

D35421

BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

BRACKET

batch: B32129

7/5/14 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32329

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D35711

GUIDE



Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s)

GUIDE

batch: 1331868

14.0

D35713

GUIDE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

GUIDE

batch: 1331869

15.0

D3572041

GUIDE ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

GUIDE ASSEMBLY

batch: 1331870

16.0

D3578041

DOUBLER



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

DOUBLER

batch: 1331865

17.0

D3610041

BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BRACKET

batch: 1332242

18.0

D36181

CAP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

CAP

batch: 32426

19.0

AN410A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch: 11106291

7/5/14 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32329

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN416A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bolt
batch: M18949 ✓

21.0

AN425A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
BOLT
batch: M14095 (4) ✓

22.0

AN444A

Eyebolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Eyebolt
batch: M19512 (2) ✓

23.0

MS24693S274

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw
batch: M100914 ✓

24.0

MS24694S56

SCREW



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
SCREW
batch: M14195 X

25.0

MS24694S58

Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)
Screw
batch: M104407 X

26.0

MS24694S60

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw
batch: M104407 X

7/5/14 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32329

Part Number: D412702041B

Job Number:



Seq. #: Machine Or Operation: Description :

27.0 AN960JD416 Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total: 104.0000 Each(s)

Washer

batch: M102929 ✓

28.0 AN960JD416L Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

batch: M102929 ✓

29.0 MS21042L4 Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Nut

batch: M103914 ✓

30.0 CR321244 Cherry Rivet



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Cherry Rivet

batch: M16612J 7/5/14 39

31.0 QCS INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP ✓ 100% 7/5/16 (2)

32.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-041B CHG001

Location:

PPP Rev: DRAFT 7/5/16 (2) (2)

Job Completion



Inspection Level 21 7/5/16

U 7/5/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1*	1*		1*		D3569-3	DECAL
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1*	1*		1*		D3569-3	DECAL
1	1			1	D412-702-105B	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-046	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1*	1*			1*	D3569-3	DECAL
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1*	1*				D3569-3	DECAL
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS

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 WORK ORDER
 NO. 32321

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1*	1*				D3569-3	DECAL
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
1			1		D412-702-115B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-046	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1*			1*		D3569-3	DECAL
1			1		D412-702-117B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-045	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1*			1*		D3569-3	DECAL
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT

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WORK ORDER

NO. 32329

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24693S58	SCREW
1	1			1	MS24693S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

25.29 Parts Lists for Dart Grommet Kits

QTY -059	QTY -069	Part Number	Description
X		D412-702-059	GROMMET KIT
	X	D412-702-069	GROMMET KIT
48		D3619-1	GROMMET
1		D3619-1T1	HOLE PUNCH
1		D3619-1T2	STRIKER BLOCK
1		D3619-1T3	PUNCH
1		D3619-1T4	DIE
	24	D3619-2	GROMMET
	1	D3619-2T1	HOLE PUNCH
	1	D3619-2T2	STRIKER BLOCK
	1	D3619-2T3	PUNCH
	1	D3619-2T4	DIE

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